

Date: Tuesday, 8/28/2007 3:23:09 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 34316	
Estimate Number : 12737	
P.O. Number : <i>N/A</i>	Part Number : D353513
This Issue : 8/28/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3535 UNDER REVIEW <i>Rev B 9/10/08-31</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 32268	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 9/14/2007 Qty: 20 Um: Each
Checked & Approved By : <i>[Signature] 08 28</i>	
Comment : Est Rev: A New Issue 07-02-15 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S20GA	304/316 .040 Sheet
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Comment: Qty.: 0.8930 sf(s)/Unit Total : 17.8605 sf(s)

304/316 .040 Sheet

(M304S20GA)

Batch: *M105130*

SAD

07/08/31

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3535

Dwg Rev: *B*

Prog Rev: *B*

2-Deburr if necessary

IB 07-09-12

SAD 07/08/31

20

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/08/31

20

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

SA 07/09/12

counted (x20)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326

2-Form joggle as per Dwg D3535 using Jig DT8158 Identify as D3535-13

SB 07/09/25

(20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 09/07/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 8/28/2007 3:23:09 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 34316

Part Number: D353513

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

fr 468/25 (20) control

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m 104846

FL 07/09/26

(20)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

W 07-09-27

(20)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: *FR-15*

FL 07/09/27

(20)

(20)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

DO 07/09/28

Job Completion



u 07.09.28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

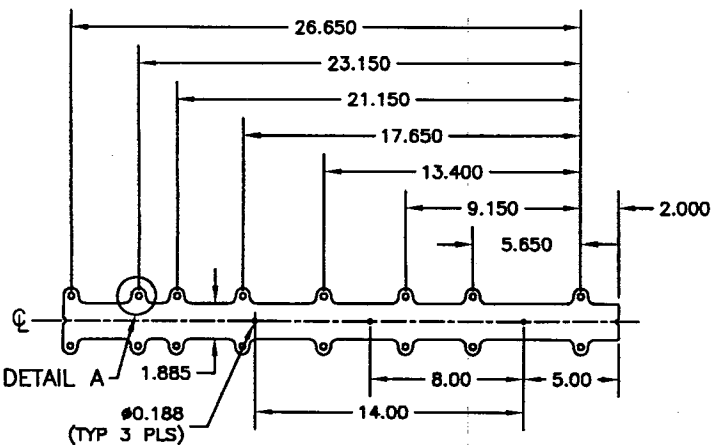
NOTE: Date & initial all entries

DART

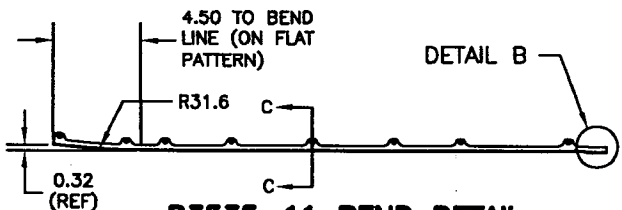
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07.04.24

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CB	PH	PORT HADLOCK, WA		
CHECKED	APPROVED	DRAWING NO.	REV. B	
#	#	D3535	SHEET 1 OF 7	
DATE		TITLE	SCALE	
07.04.17		WEARSHOE	1:10	
A	06.10.25	NEW ISSUE		
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC		

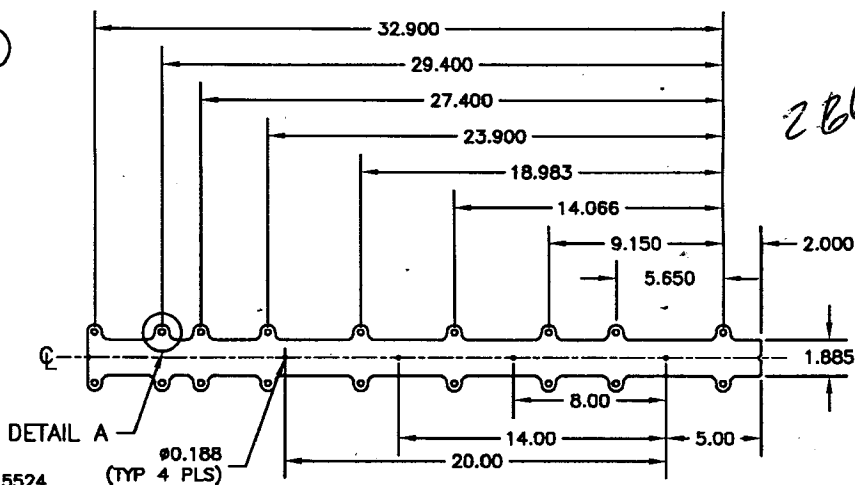


D3535-11F FLAT PATTERN

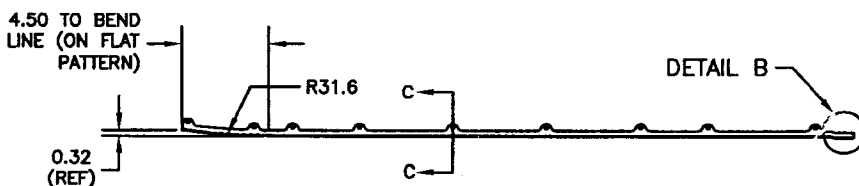


D3535-11 BEND DETAIL

NO. 34316
WORK ORDER
SUBJECT TO AMENDMENT
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D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

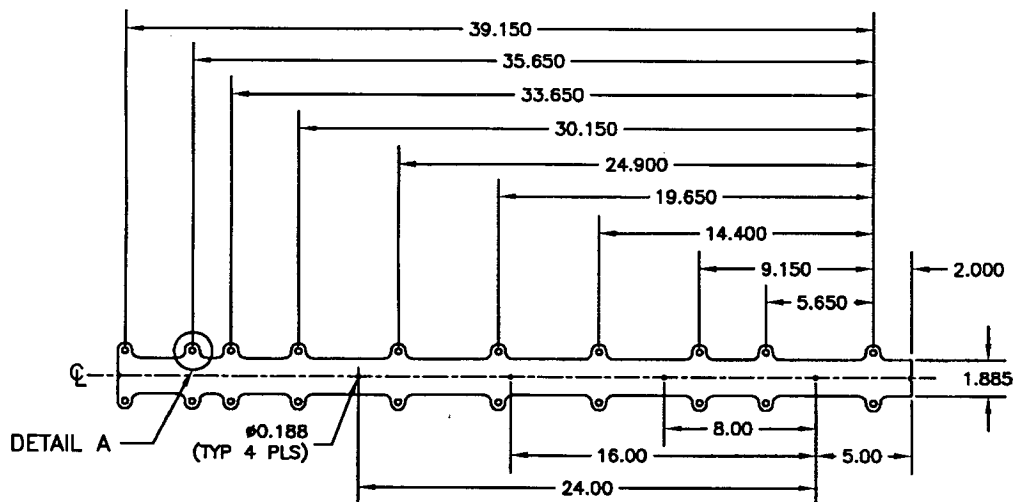
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DART

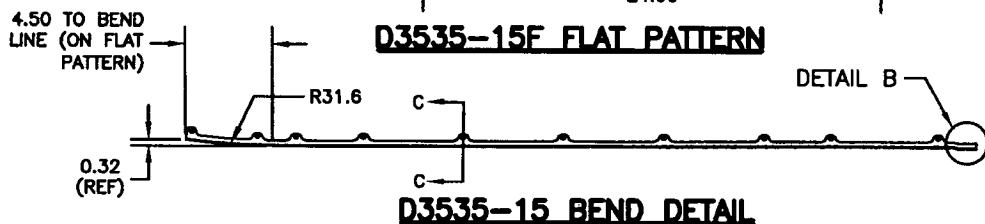
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07.04.24

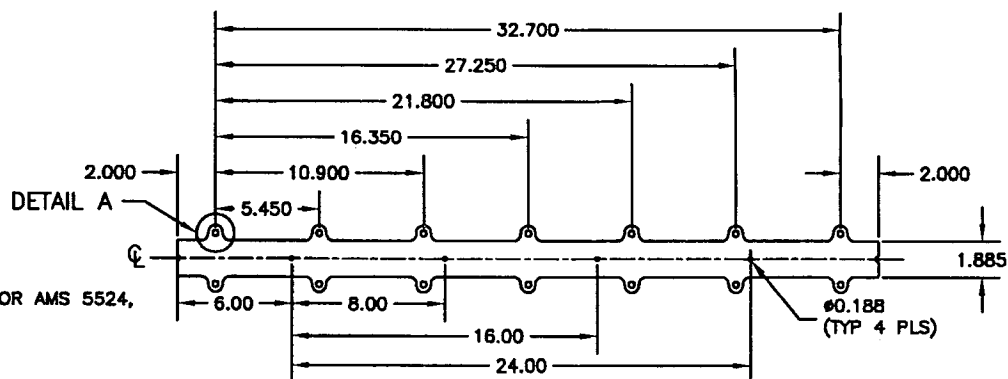
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C.B.	M.H.	PORT HADLOCK, WA		
CHECKED	APPROVED	DRAWING NO.	REV. B	
<i>[Signature]</i>	<i>[Signature]</i>	D3535	SHEET 2 OF 7	
DATE	TITLE	SCALE		
07.04.17	WEARSHOE	1:10		



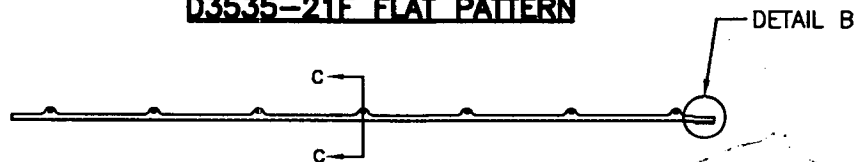
D3535-15F FLAT PATTERN



D3535-15 BEND DETAIL



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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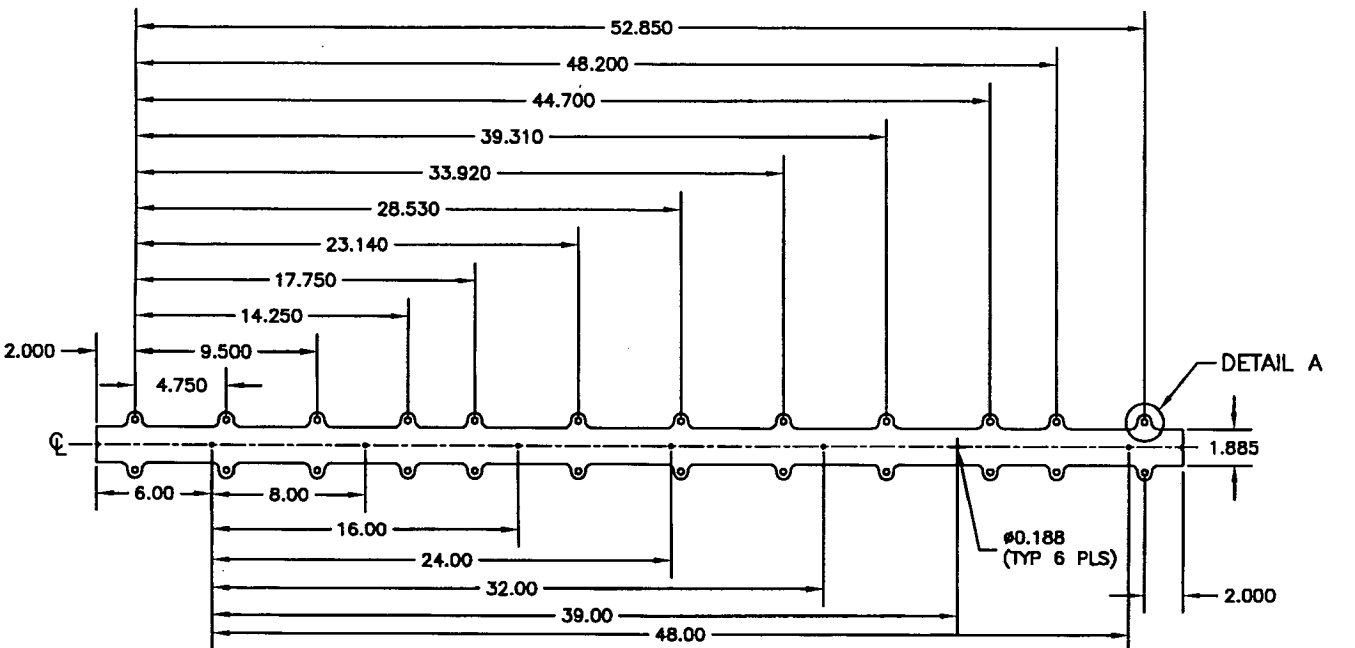
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DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 3 OF 7
		SCALE	1:10	

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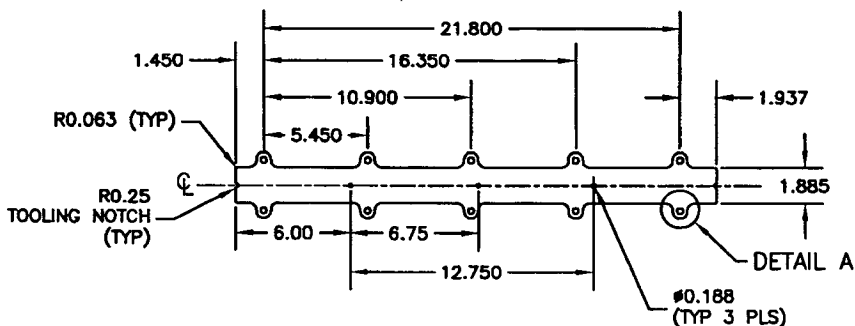
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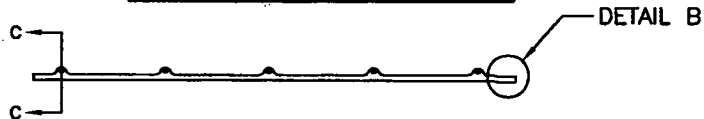
D3535-23F FLAT PATTERN



D3535-23 BEND DETAIL



D3535-25F FLAT PATTERN



D3535-25 BEND DETAIL

NOTES

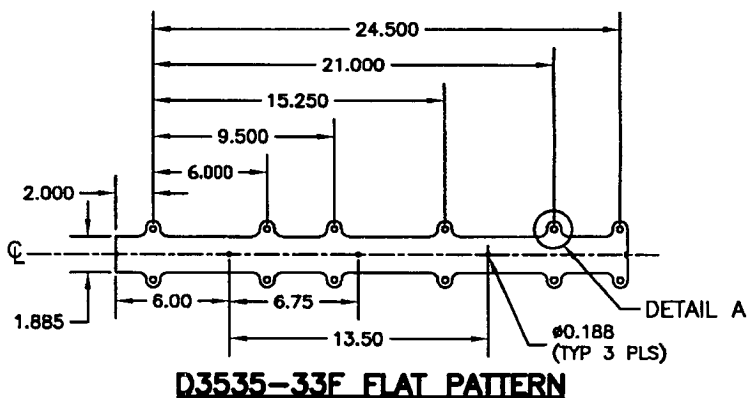
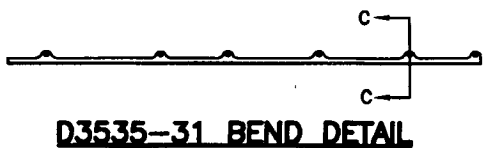
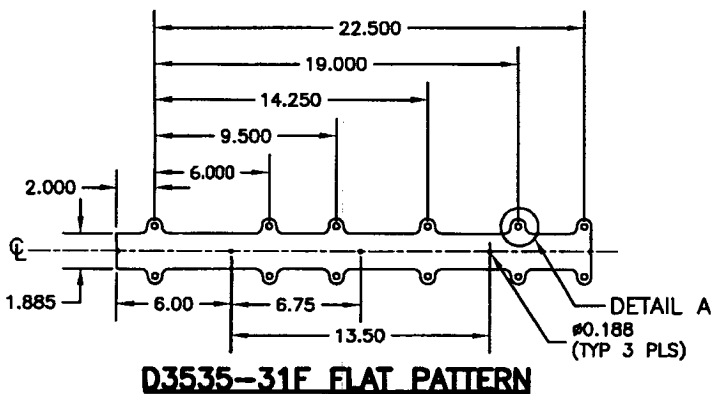
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NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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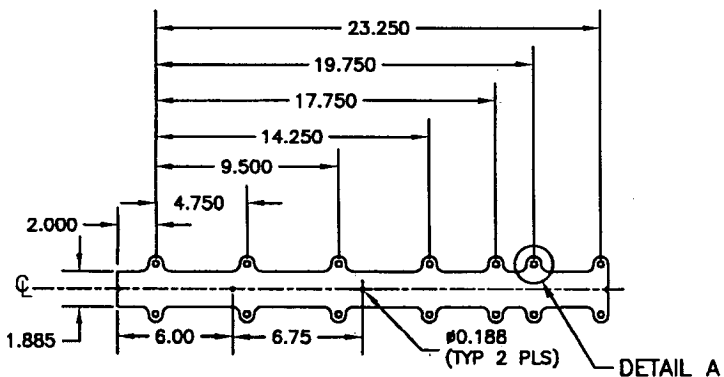
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CB	PH	PORT HADLOCK, WA		
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		D3535	SHEET 4 OF 7	
DATE		TITLE	SCALE	
07.04.17		WEARSHOE	1:10	

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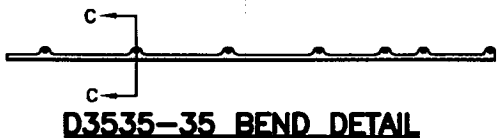
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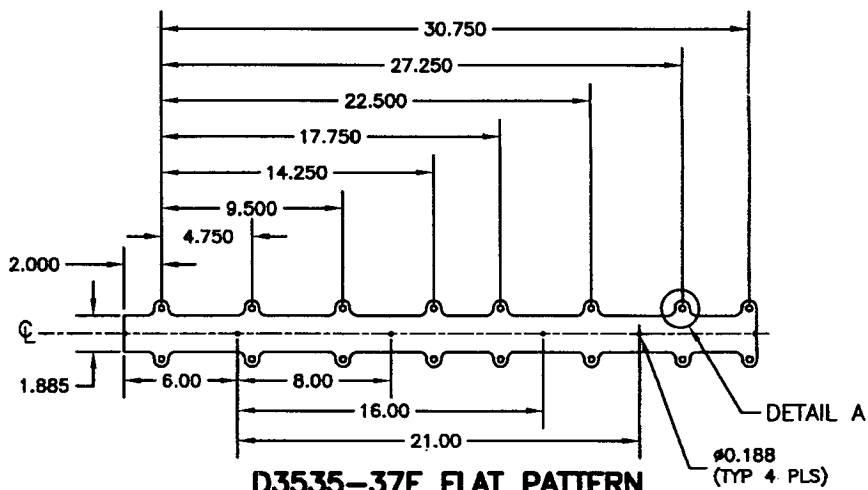
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CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. B
<i>[Signature]</i>	<i>[Signature]</i>	D3535	SHEET 5 OF 7
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	



D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

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NO. 24316

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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DRAWING NO.

REV. B

DATE

TITLE

D3535

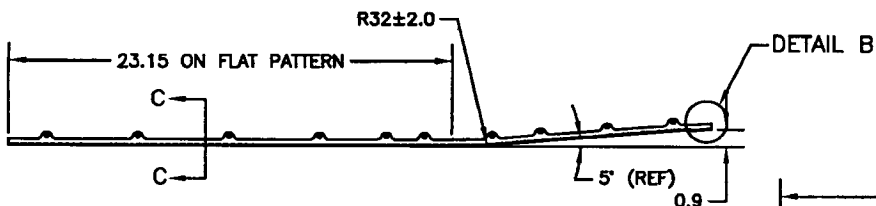
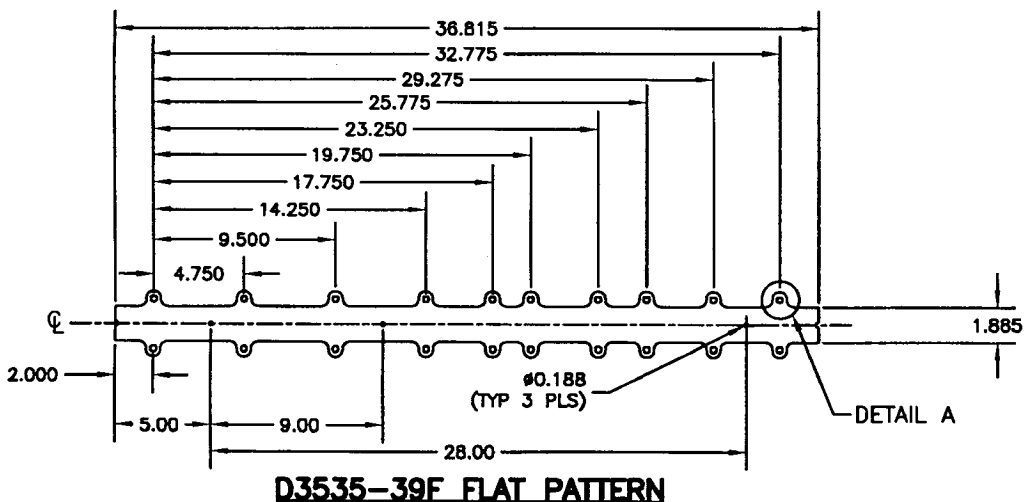
SHEET 6 OF 7

07.04.17

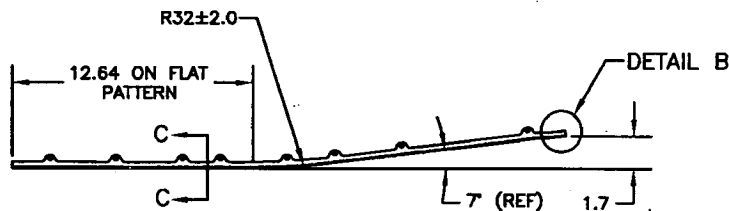
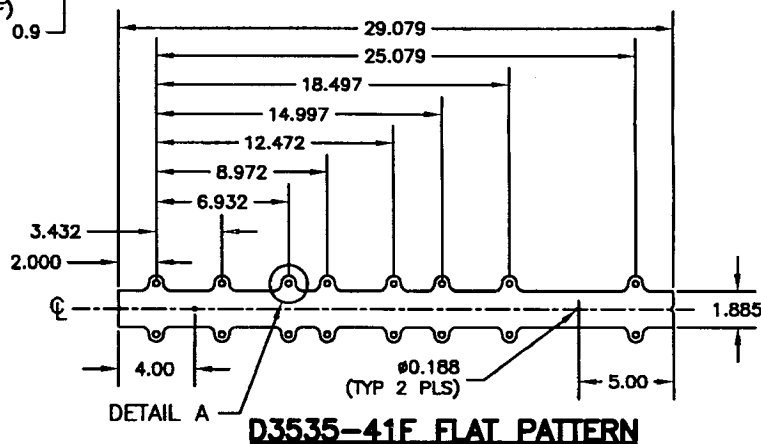
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SCALE
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07.04.24



D3535-39 BEND DETAIL



D3535-41 BEND DETAIL

NOTES

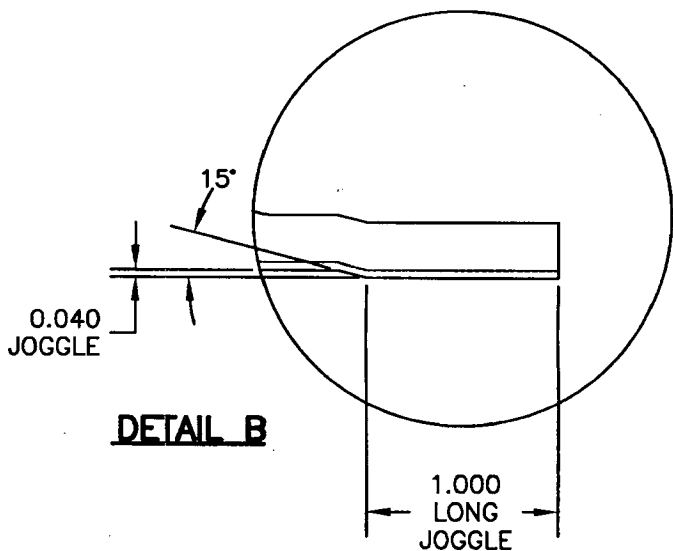
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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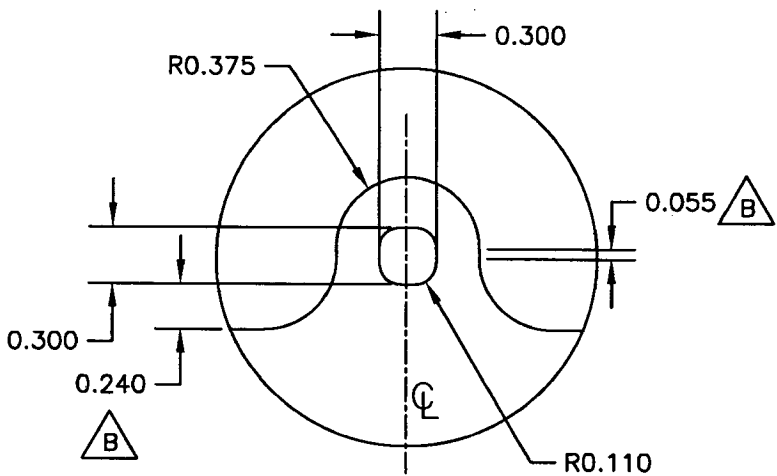


DESIGN	C.B.	DRAWN BY	PH	DART AEROSPACE USA, INC.	REV. B
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA	
DATE	07.04.17	DRAWING NO.	D3535	TITLE	SHEET 7 OF 7
				WEARSHOE	SCALE 1:1

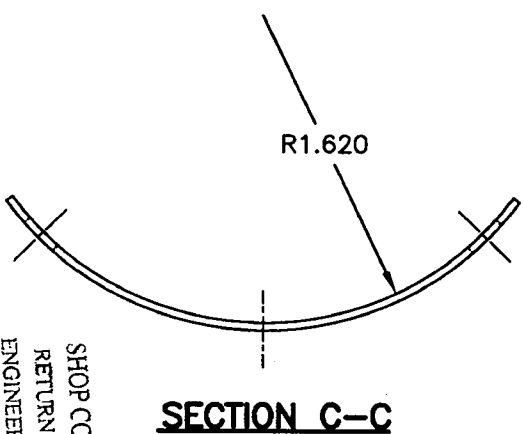
RELEASED
07.04.24 *[Signature]*



DETAIL B



DETAIL A



SECTION C-C

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WORK ORDER
NO. 34316

DART AEROSPACE LTD		Work Order:	34316
Description: WEARSHOE		Part Number:	D353513
Inspection Dwg: D3535 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
32.900	+/- 0.010	32.900	✓		M-T	
29.400	+/- 0.010	29.300	✓		M-T	
27.400	+/- 0.010	27.400	✓		M-T	
23.900	+/- 0.010	23.900	✓		M-T	
18.983	+/- 0.010	18.990	✓		M-T/Vern	
14.066	+/- 0.010	14.062	✓		M-T Vern	
9.150	+/- 0.010	9.155	✓		Vern	
5.650	+/- 0.010	5.652	✓		Vern	
Ø 0.188	EL +0.005 0.000	Ø 0.191	✓		Vern	
20.000	+/- 0.010	20.000	✓		M-T	
14.000	+/- 0.010	15.000	✓		M-T	
8.000	+/- 0.010	8.000	✓		M-T	
1.885	+/- 0.010	1.884	✓		Vern	
2.665	+/- 0.010	2.666	✓		Vern	
0.038	+/- 0.010	0.033	✓		Vern	
0.300	+/- 0.010	0.300	✓		Vern	
0.300	+/- 0.010	0.300	✓		Vern	

Measured by: SAN	Audited by: Er	Prototype Approval: M/A
Date: 07/08/31	Date: 07/09/04	Date: M/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	